



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6305G00132-3G

Job Sheet 175863



Part No: RBW6305G00132-3G

Job Qty: 1 ea

Part Name: AW139 Gimbal Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/11/18

Job Tracking No:

Due Date: 4/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6305G00132-3G Rev 4 IPP Rev A 18.02.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
60	Purchasing	1 pcs		4/28/18	0.00	0.00	Purchasing Start Up		AF 18/05/24
70	Packaging	1 pcs		4/28/18	0.00	0.00	Packaging2		AF 18/05/24
80	QC	1 pcs		4/28/18	0.00	0.00	QC6		38
90	Small Fab	1 pcs		4/28/18	0.00	0.00	Small Fab-4		9-88
110	Small Fab	1 pcs		4/30/18	0.00	0.25	Small Fab-4		MLL DAE
120	QC	1 pcs		4/30/18	0.00	0.00	QC5		38
130	Packaging	1 pcs		4/30/18	0.00	0.00	Packaging3-1		GAISS 18-06-06
140	QC21-FG	1 Ea		4/30/18	0.00	0.00	QC21		21 JUN 07 2018

Part Op 60 - Issue PO to ARROW TECH MACHINE WORKS P/O: 39580 MANUFACTURE RBW6305G00132-3G AS PER
Descriptions: DWG. -Certificate of conformity is required

110 - 1-Glue placard RBW6305G00132-3G-11 to RBW6305G00132-3G-9 foam as per DWG. 2-Glue foam to case and pack case as per DWG.

✓1 MAY 09 2018 DAS 13 9-88

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6305G00132-3GP	AW139 Gimbal Bushing	1 pcs (1 ea)	60-Purchasing	5074073
APP-1120-E	Case	1 Ea (1 ea)	90-Small Fab	5060687
RBW6305G00132-3G-11	Placards	1 Ea (1 ea)	90-Small Fab	5077469
RBW6305G00132-3G-7	Bottom Foam	1 Ea (1 ea)	90-Small Fab	5060689
RBW6305G00132-3G-9	Top Foam	1 Ea (1 ea)	90-Small Fab	5060692
RBW6305G00232-3G	Gimbal Torque Tube Bushing Installer	1 Ea (1 ea)	90-Small Fab	
RBW6305G001232-3G	Gimbal Torque Tube Bushing Remover	1 Ea (1 ea)	90-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
60-Purchasing	RBW6305G00132-3GP	1	0	0
90-Small Fab	APP-1120-E	1	0	0
	RBW6305G00132-3G-11	1	0	0
	RBW6305G00132-3G-7	1	0	0
	RBW6305G00132-3G-9	1	0	0
	RBW6305G00232-3G	1	0	0
	RBW6305G01232-3G	1	0	0

Part Specifications



Container No: S074090



Part: RBW6305G00132-3G

Job No: 175896 175863

Serial No/Batch: S074090

Revision: 4

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/24/18

3AC
8C
3C

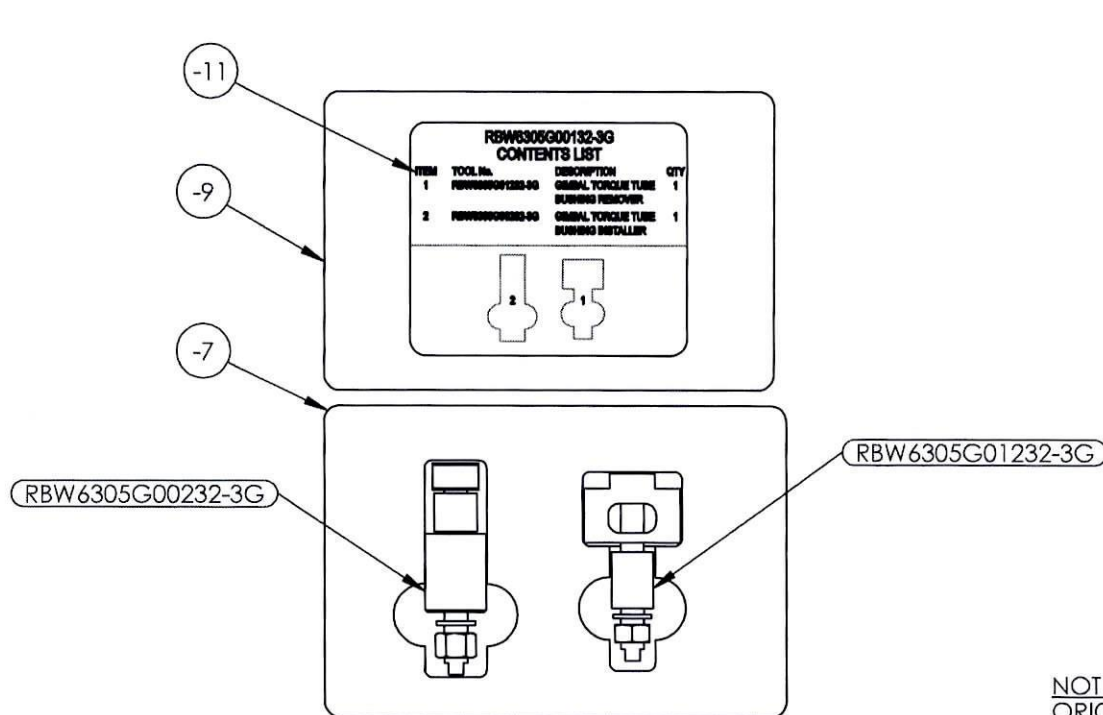
3AC
8C
3C

Specifications could not be found.

Plex 4/11/18 11:21 AM Dart.lajeunesse.marie

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REVISIONS					
REV	EGR	DESCRIPTION	DATE	INITIAL	APPROVED
2		-29 CH'D THICKNESS FROM .31. -31 CORRECTED TOOL NUMBERS.	5/11/2011	RJC	RW
3		-7 CH'D CUTOUTS FROM .87 TO 1.00, AND 1.60 TO 1.62. ADDED FINGER GRAB CUTOUTS. -9 CH'D PLACARD CUTOUT DEPTH FROM .07 TO .10.	10/29/2012	RJC	SE
3A		-7 CH'D DIM WAS R.125 IS R.13. -9 ADDED SECTION A-A, CH'D DEPTH WAS .10 IS .13, CH'D DIM WAS R.375 IS R.38. -11 CH'D DIM WAS .06 IS (.06).	5/5/2014	DPD	RJC
4	15-0322	-9 CH'D DIMS WAS 4.75 IS 4.80, WAS 7.13 IS 7.30, WAS .40 IS .72, WAS 6 IS 4.50, WAS 3.00 IS 3.75 WAS 4X R.38 IS 4X R.25. -11 CH'D DIM'S WAS 2.50 IS 3.75, WAS 6.00 IS 4.50 WAS R.38 IS R.25. ADDED TOOL OUTLINES & ITEM NUMBERS.	10/5/2015	RJC	JAG



NOTES:
ORIGINAL No. FOR REFERENCE ONLY:
RBW6305G00132-3G = 3G6305G00132

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	GIMBAL TORQUE TUBE BUSHING REMOVER		RBW6305G01232-3G	1
				1	GIMBAL TORQUE TUBE BUSHING INSTALLER		RBW6305G00232-3G	1
		B/O	-5	1	CASE	PLASTIC	PELICAN #APP1120-E	N/S
		B/O	-7	1	BOTTOM FOAM	Y20 BLACK	2-5/8 X 5 X 7-1/2 I.R. SPECIALTY FOAM	2
		B/O	-9	1	TOP FOAM	Y20 BLACK	23/32X 4-3/4 X 7-5/16 I.R. SPECIALTY FOAM	3
			-11	1	PLACARD	PLASTIC		4

DART AEROSPACE	
TITLE GIMBAL BUSHING KIT	
DWG NO. RBW6305G00132-3G	REV 4
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/8 ANGLES ± 5°	DRAWN BY: PERRITT APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AGUSTA
SCALE 1:3	DATE 1/13/2009 SHEET 1 OF 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐			
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Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039580**

Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO039580

PO Date: 4/11/18

Due Date: 6/2/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

REVISED

\$

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Ship To:

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	RBEGM-745-064P			Removal/Installation-Motor Pump Cartridge (Forward Main Tank) WO 175829 AND WO 175826	Firmed	5/11/18	2 Ea	0 Ea	2 Ea	\$1,736.93/Ea	\$3,473.86
							<i>12x</i>			<i>AT 19/05/18</i>	
2	RBW109-3130-85-133P			Tool Kit, Tail Rotor Pitch Control Shaft Bearing Remove/Install WO 175827 AND WO175893	Firmed	5/25/18	2 Ea	0 Ea	2 Ea	\$1,766.68/Ea	\$3,533.36
							<i>2x</i>			<i>incl 18/05/23</i>	
3	RBEL133M-6503-101P			Mounting Tool	Firmed	5/18/18	2 Ea	0 Ea	2 Ea	\$1,753.73/Ea	\$3,507.46
							<i>2x</i>			<i>incl 18/05/23</i>	
4	RBD29828P			Elastomeric Bearing Removal Tool WO 175825	Firmed	6/4/18	2 Ea	0 Ea	2 Ea	\$551.91/Ea	\$1,103.82
							<i>2x</i>			<i>AT 18/05/24</i>	
5	RBW6305G00431-3GP			Hoisting Flange Main Gear Box WO 175830	Firmed	5/29/18	4 pcs	0 pcs	4 pcs	\$1,013.90/pcs	\$4,055.60
6	RBE117-11181W1P			Main Rotor Drive Mounting Tool WO 175881, WO 175882, WO 175883 WO 175885	Firmed	5/11/12	4 Ea	0 Ea	4 Ea	\$2,603.98/Ea	\$10,415.92
							<i>4x</i>			<i>AT 18/05/18</i>	
7	RBW6305G00132-3GP			AW139 Gimbal Bushing WO 175863, WO 175864, WO 175865	Firmed	5/29/18	3 pcs	0 pcs	3 pcs	\$1,080.39/pcs	\$3,241.17
							<i>3x</i>			<i>AT 19/05/24</i>	



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No:039580

Dated: 5/23/2018

Our Order / Job No:039580-07AWT

Order Qty: 3

Part Name: GIMBAL TORQUE TUBE BUSHING INSTALLER

Part Number: RBW6305G00132-3G

Lot Size:N/A

Ship Date: 5/23/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBW6305G00132-3G

Rev: 2

Material Size and Type:(RBW6305G00232-3G REV -2)-1,-3,-5,-7/4140 Q&T;
(RBW6305G01232-3G REV-3)-1,-3,-5/4140 Q&T STEEL

Material Specifications: STEEL: ASTM A108, ASTM A29

Heat Treatment: N/A

Plating/Finish:

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 5/23/18

Signed: Henrietta Sahl

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com